

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022755**Date Inspected:** 05-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in the Bay 10:

SMAW repair welding of weld joint BK17C-001-068 located on PCMK OBG bike path cantilever beam. Welder was identified as 500363. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Shi Yu (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20590 as presented to this QA Inspector and verbally identified by QCA1. See photos below showing ZPMC welder 500363 cleaning the first of 2 repairs to weld joint BK17C-001-068 and ZPMC Report of Ultrasonic Examination #UT-20446 which was attached to ZPMC Weld Repair Report B-WR20590.

Fit-up and SMAW tack welding of weld joints 31TR1-001-002, 004, 008, 011, 013, 016 located on PCMK OBG traveler rail. Welder was identified as 040570. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212 and WPS-B-P-2214 as verbally identified by QCA1.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

Bay 11

This QA Inspector randomly observed the following work in progress in the Bay 11:

SMAW repair welding of weld joints 32TR1-001-008, 009, 013, 014 located on PCMK OBG traveler rail. Welders were identified as 040614, 046704, 046769. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Mao Bin Bin (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20595 as presented to this QA Inspector and verbally identified by QCA2.

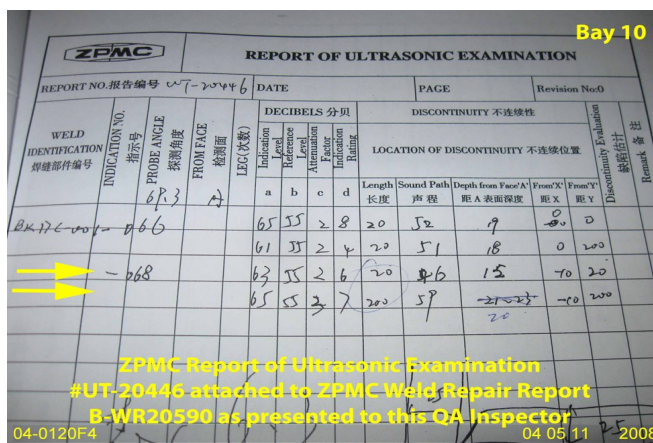
OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of weld joint SEG3007-010 located on PCMK OBG Segment 13AE. Welder was identified as 200113. QC was identified as ABF CWI Bao Qian (QC3). Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20567 as presented to this QA Inspector and verbally identified by QCA3.

SMAW repair welding of weld joints SEG3007L-006, 010 located on PCMK OBG Segment 13AE. Welder was identified as 068924. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20507 as presented to this QA Inspector and verbally identified by QCA3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken
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QA Reviewer
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